Work Order ID 51237

August 12, 2009 8:12:37 AM

Item ID:

D3063-1

Revision ID:

Item Name: Support

Start Date:

Reference:

Approvals:

8/12/09

Start Oty: 40.00

Required Date: 8/18/09

Reg'd Oty: 40.00

Process Plan:

QC:

Operation

Revision Nbr

Description

Draw Nbr

Work Center ID

Sequence ID/

D3063 Rev A

100

SHEAR

Shear

Shear

110

Memo Cut blanks 4.000" x 2.500" x 0.625" thick

Date:

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

Memo

Memo

0.00

Accept

SPC (Y/N):

Set Up/

Run Hours

1-Machine per folio FA175 and Dwg D3063112-Deburr & Tumble

Date: 09/08/12 Tooling:

0.00

0.00

0.00

dr/80/40

120

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

0.00

W/80/40

Setup Start Stop

Cust Item 1D:

Customer:

Draw

Number

Date:

Date:

Draw

Rev.

Plan

Code

Run

Accept

Otv

Start

Stop

Reject

Insp. Stamp

Number

Reject

Oty

Dart Aerospa	ice l	_td
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W/O:			W	ORK ORDER CHANG	ES	•••••				
DATE	STEP	PRO	OCEDURE CH	ANGE	Ву	,	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Cat	tegory:	NCR: Y	es N	o DQ	\:	Date:	
		esolution:								
NCR:		\	WORK ORI	DER NON-CONFORM	ANCE (N	CR)				
DATE	STEP	Description of NC			ion B	_	Verific	ation	Approval	Approval
DAIL	JILF	Section A	Initial Chief Eng	Action Description Chief Eng		gn & ate	Section		Chief Eng	QC Inspector
	i									

. NOTE: Date & initial all entries

Work Order ID 51237

August 12, 2009 8:12:37 AM

Item ID:

D3063-1

Revision ID:

Α

Item Name:

Support

Start Date:

8/12/09

Required Date: 8/18/09

Start Oty: 40.00

Operation

Description

Req'd Qty: 40.00

Reference:

Approvals:

Process Plan:

QC:

Date:

Date:

SPC (Y/N):

Set Up/ **Run Hours**

0.00

0.00

0.00

0.00

Tooling:

QC8- Inspect parts - second check

Sequence ID/

Work Center ID

Quality Control

130

Memo

Memo

Identify as per dwg & Stock Location:

140

Packaging

Packaging

150

Quality Control

QC21- Final Inspection - Work Order Release

Memo

0.00

0.00

Accept



Setup Start



Cust Item ID:

Customer:

Draw

Number

Date:

Date:

Draw

Rev.

Plan

Code

Run

Accept

Qty

Start



Stop

Reject

Oty

Reject Insp.

Number Stamp

40 1

/c9/8/18

Dart	Ae	ros	na	CP	l td
		03	vu	-	

W/O:	,		WOF	RK ORDER CHANG	ES					
DATE	STEP	PRO	OCEDURE CHAN	GE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	· 	PAR #:	Fault Catego	ory:	NCR	R: Yes N	lo DQ	A :	Date:	
		esolution:							The second secon	
NCR:			WORK ORDE	R NON-CONFORMA	NCE	(NCR)				
DATE	STEP	Description of NC Section A	Initial Chief Eng	orrective Action Section Action Description Chief Eng	on B	Sign & Date	Verific Section		Approval Chief Eng	Approval QC Inspector
	,									

NOTE: Date & initial all entries

Picklist Print

August 12, 2009 8:12:37 AM

Work Order ID: 51237

Parent Item:

D3063-1RevA

Parent Item Name: Support

Comments:



Start Date: 8/12/09

Required Date: 8/18/09

Start Qty: 40.00

Required Qty: 40.00

Component Item ID/ Item Name

Replacement Mfg/ Item ID

Purch

Primary Item Location

Last Location

Route Seq ID Unit of Measure Hand

Qty on

Remaining Qty To Pick Issued

Qty

Status

M6061T6B0.625X02.50

Purchased

100

Issued

Date

No

23.2000

14.3874



6061-T6 Bar .625 x 2.50

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

23.2 23.2

108961

Dart Aerospace Lt	td	.td	tc	Ľ	ı	е	:(C	а	ì	D	S	0	r	е	А	τ	ar	υ	
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W/O:			W	ORK ORDER CHAI	NGES			· · · · · · · · · · · · · · · · · · ·		
DATE	STEP	PRO	CEDURE CH	ANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No.	<u> </u>	PAR #:	Foult Col		NO.	D. Voo. I	Jo DOA		Data	
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		esolution:							Date:	
NCR:		V	VORK ORI	DER NON-CONFOR	MANCE	(NCH)			•	
DATE	STEP	Description of NC	Imitial	Corrective Action	Section B	Sign &	Verific		Approval	Approval
		Section A	Initial Chief Eng	Action Description	ou · ·	Date	Section	n C	Chief Eng	QC Inspector
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NOTE: Date & initial all entries

L H:\fFQRMS\Quality Assurance\approved QA\NCRWO RevE

DART AEROSPACE LTD	Work Order:	51237
Description: Support	Part Number:	D3063-1
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Inspection Dwg: D3063 Rev: A		Page 1 of 1

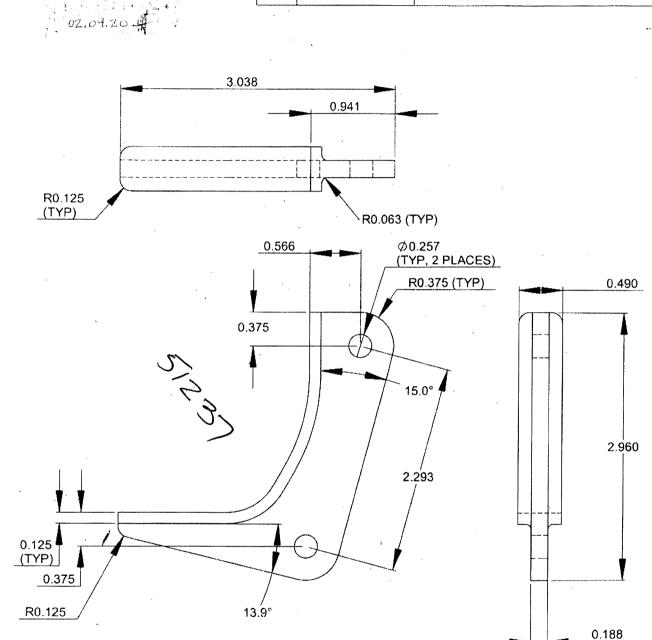
	FIRS	T ARTICLE II	NSPECTI	ON CHE	ECKLIST		
	Х	First Arti	cle	Prot	otype		
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Con	nments
R0.063	+/-0.010	A 063					
R0.125	+/-0.010	del 10					
0.566	+/-0.010	.565					
0.375	+/-0.010	.374					
Ø0.257 -	+0.005/-0.000	260				· 	<u> </u>
R0.375	+/-0.010	Q.375	٠.		·		
0.125	+/-0.010	.135					
2.293	+/-0.005	7.964					
0.490	+/-0.010	.484					
0.188	+/-0.010	788					
2.960	+/-0.010	2.967			, .		
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Measured by:	mu F	Audited by:	m	Prototype Approval:	N/A
Date:	0408(16	Date:	01/08/17	Date:	N/A

Rev	Date	Change	Revised, by	Approved
Α	04.01.21	New Issue	KJ/RF	17



DESIG	P	DRAWN BY		AEROSPA SBURY, ONTARI	
CHECK	ED 	APPROVED	DRAWING NO		REV. A SHEET 1 OF 1
DATE	02.0	09.10	SUPPORT	7.5%	SCALE 1:1
Α	0	2.09.10	NEW ISSUE	•	



D3063-1 SUPPORT

- 1) MACHINE PER DWG FILE "D3063-1.SLDPRT"
- 2) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-225/8 OR QQ-A-250/11) (REF DART SPEC M6061T6B OR M6061T6S)

- 3) FINISH: NONE
 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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